











SPL

Date: Monday, 07/07/2008 4:23:30 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SLIDING DOOR BRACKET
Job Number	: 40347	Part Number	: D36751
Estimate Number	: 13275	Drawing Number	: D3675 REVA
P.O. Number	:	Project Number	: N/A
This Issue	: 07/07/2008 S.O. No. :	Drawing Revision	: A
Prsht Rev.	: NC	Material	:
First Issue	: / / Type : SMALL /MED FAB	Due Date	: 28/07/2008
Previous Run	: 38804	Qty:	120 Um: Each
Written By	:		
Checked & Approved By	: <u>JUL 08.7.07</u>		
Comment	: Est Rev:A new issue 08-04-21 DD verified by:EC		
Additional Product			
Job Number: 			
Seq. #:	Machine Or Operation:	Description :	
1.0	M304S20GA	304/316 .040 Sheet	
			
<p>Comment: Qty.: 0.1271 sf(s)/Unit Total: 15.2460 sf(s) <u>109023</u></p> <p>304 stainless steel 0.032" Sheet</p> <p>Batch: <u>109023</u> <u>B 8-8-26</u> <u>20</u> <u>MAT NOT PULLED</u></p>			
2.0	WATER JET	FLOW WATER JET	
			
<p>Comment: FLOW WATER JET</p> <p>1-Cut as per Dwg D3675</p> <p>Dwg Rev: <u>A</u> <u>B 8-8-26</u></p> <p>Prog Rev: <u>A</u> <u>(13)</u></p> <p>2-Deburr if necessary <u>B 8-8-26</u></p>			
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
			
<p>Comment: INSPECT PARTS AS THEY COME OFF MACHINE</p>			
4.0	QC8	SECOND CHECK	
			
<p>Comment: SECOND CHECK <u>S 08/08/07</u> <u>(+130)</u> <u>center</u></p>			
5.0	BRAKE NC	NC BRAKE	
			
<p>Comment: NC BRAKE</p> <p>Form as per Dwg D3675 <u>SB 08/08/02</u> <u>92</u></p>			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: SLIDING DOOR BRACKET

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Part Number: D36751

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/10/02
97
97

7.0

POWDER COATING

POWDER COATING



M 106442



97X

Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

1:05
320
1:45

M. 08/10/02

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

08/10/03
97

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

238a

08/10/06
97

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/06
97

Job Completion



08/10/06
97

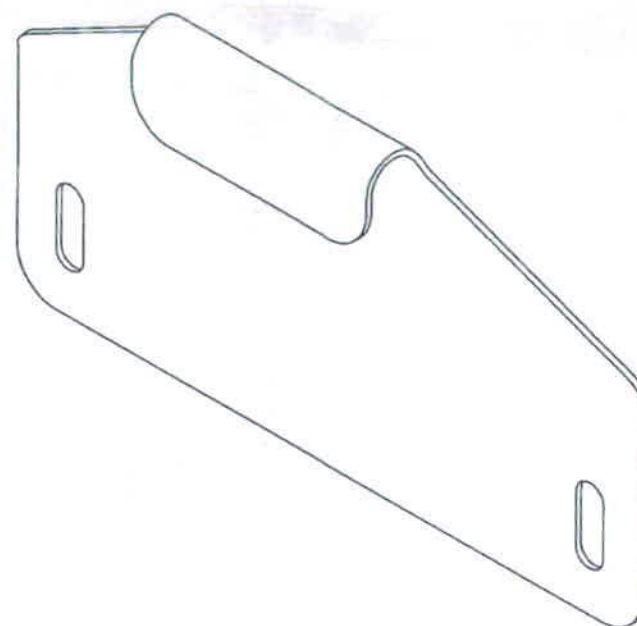
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3675-1 SLIDING DOOR BRACKET

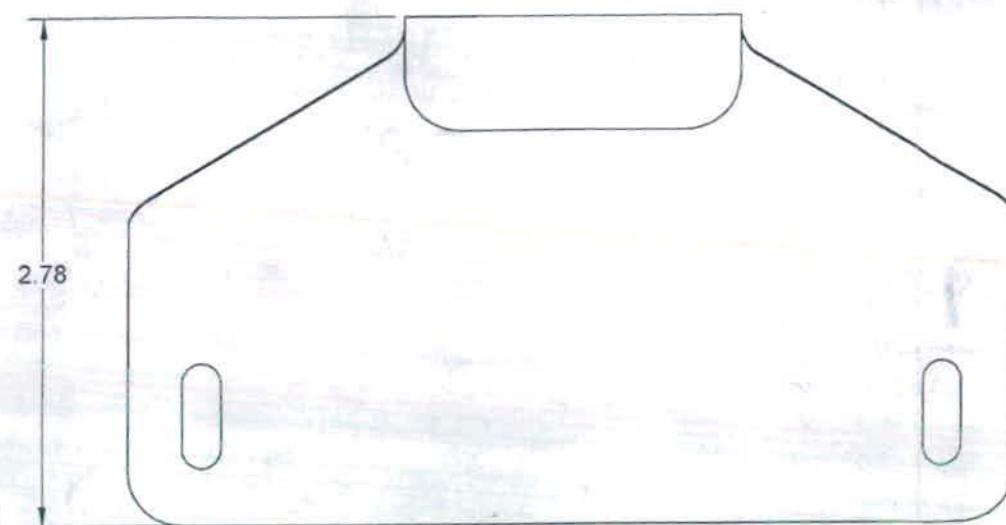
NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 0.040 THICK
PER MIL-S-5059 (ANNEALED)
REF. DART SPEC M304S
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3675-1" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.15 lbs
- 8) THE D3675-1 SLIDING DOOR BRACKET IS A DERIVATIVE OF THE D3199-1 BRACKET.

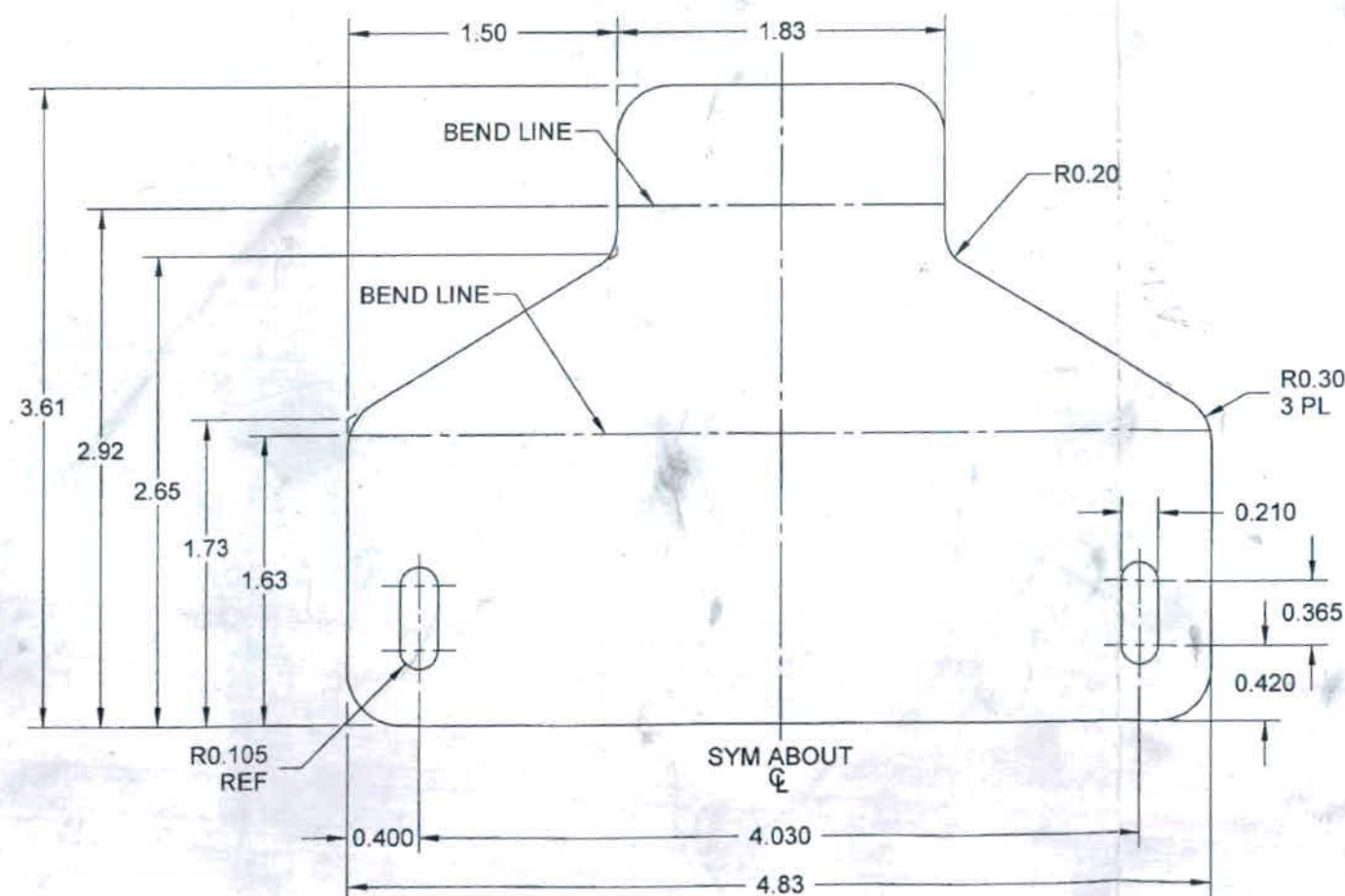
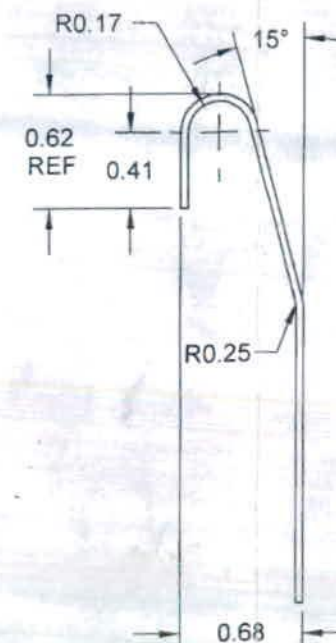
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40347

RELEASED
08-06-26/11P

A	NEW ISSUE	AJS	08.03.27
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ASS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3675	SHEET 1 OF 2
APPROVED		TITLE	SLIDING DOOR BRACKET
DE APPR.		(COMPOSITE DOOR)	SCALE NTS
DATE	08.03.27	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3675-1 SLIDING DOOR BRACKET
(MAKE FROM D3675-1F)



D3675-1F FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40347

RELEASED
08.06.76

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3675	SHEET 2 OF 2
APPROVED		TITLE	SLIDING DOOR BRACKET SCALE
DE APPR.		(COMPOSITE DOOR)	NTS
DATE	08.03.27	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
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